

Date Wednesday, 15/08/2007 4:00:20 PM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 33937					
Estimate Number	: 10267					
P.C. Number	: N/A			Part Number	: D2438	
This Issue	: 15/08/2007		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2438 REV. C	
First Issue	: N/A		Type	: PURCHASED PARTS		
Previous Run	: 32016			Project Number	: N/A	
Written By	:			Drawing Revision	: C	
Checked & Approved By	:			Material	: N/A	
Comment	: Est: E 05.06.28 Bending removed KJ/JLM			Due Date	: 31/08/2007	
					Qty:	200 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	 <b>Comment:</b> PURCHASING Issue P/O: 4371 <i>C20710314</i> Laser cut(s) per Dwg D2438 GFF <i>W</i> <i>(200)</i> Material release note is required
2.0	D2438B	Clamp	 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) CLAMP
3.0	PACKAGING 1	PACKAGING RESOURCE #1	 <b>Comment:</b> PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>7/9/18 SIC</i> <i>(200)</i>
4.0	QC6	DIMENSIONAL CHECK	 <b>Comment:</b> DIMENSIONAL CHECK Inspect dimensions as per Dwg D2438 (6.786" center to center) <i>QSP019</i> <i>En 07/02/19</i> <i>x 200</i> <i>counts</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr any rough edges <i>SAD</i> <i>07/09/23</i> <i>201</i> <i>counts</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:20 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 33937

Part Number: D2438

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Er 10/09/24 (201) counter

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10/09/24 (201)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



(201)  
10/09/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/09/24 (201)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

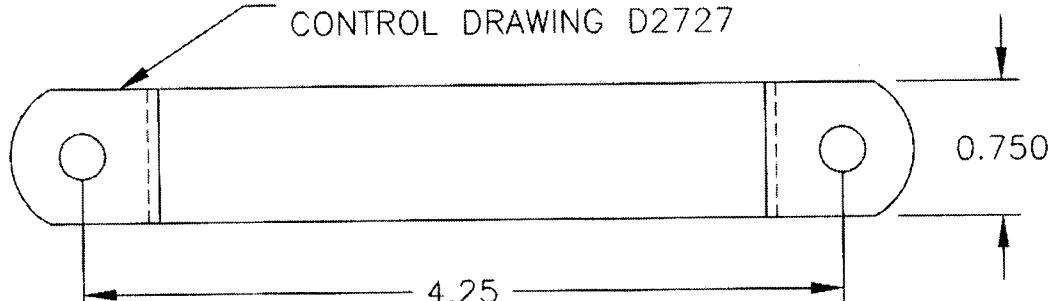
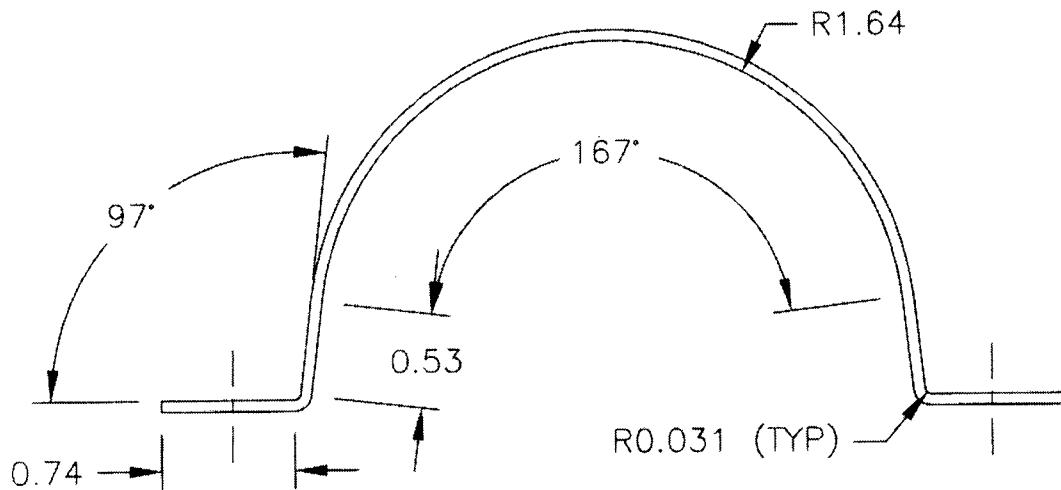
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MW</i>	APPROVED <i>CD</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE.	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

**RELEASED**  
18.06.17 KB

W/I/O: 33937

FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

#00606  
CP 05/05/97



Member de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

# CERTIFICATE OF COMPLIANCE

## CERTIFICAT DE CONFORMITE

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **11** OUR JOB NO **J0167069** SHIPPING MEMO **0373992**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<b>1</b>	<b>200 PCS</b>	<b>PO00004371</b>	<b>D2438B</b>	<b>C</b>	<b>CLAMP</b>	<b>C</b>

MATERIAL	SUPPLIED BY	MAT. REL. NO.
<b>S.S.T 304</b>	<b>SIGMA METALS</b>	<b>824074</b>

	PROCESS	PROCESSOR	RELEASE NOTE #
<b>1</b>	<b>FIRST ARTICLE INSPECTION REPORT ON FILE</b>	<b>GFI</b>	<b>CONFORMS</b>
<b>2</b>			
<b>3</b>			
<b>4</b>			
<b>5</b>			
<b>6</b>			
<b>7</b>			
<b>8</b>			
<b>9</b>			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATI: **14 SEPTEMBER 2007**

G.F.I. Q.C. REP.



**Sigma Metals Inc.**  
45 Jeffry Blvd.  
**Deer Park, NY 11729**  
*A Small Woman Owned Business*  
(631) 243-2100 • (800) 471-

# Packing Slip

DATE INVOICE NO.  
2/27/2007 43030

## BILLETO

**G E INC.  
110 AVENUE LABROSSE  
POINT-CLAIRE  
QUE. CANADA  
H9R 1A1**

**SHIP TO**

**GFI INC.**  
**180 AVENUE LABROSSE**  
**POINT-CLAIRE**  
**QUE, CANADA**  
**H9R 1A1**

PO. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
1070988	Net 30	MEC	YELLOW	DEER PARK,NY	59828

ITEM	DESCRIPTION	QTY
SS SHEET	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 063" X 48" X 36" 189 LBS. MILL: ATI LOT# 824074 REPLACEMENT <del>NO. 4680</del> BOXING CHARGE GFI INJ.	6
BOXING	✓ MATERIEL REÇU NE SERA ACCEPTÉ ✓ APRÈS VÉRIFICATION DE DIMENSIONS, ÉPAISSEUR, POIDS ET CONDITIONS	1

## SIGNATURE

DATE 01 MAR 07

## **CERTIFICATE OF COMPLIANCE**

**THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT THE TERMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL CERTIFICATIONS, CERTIFICATION AND CHEMICAL AND PHYSICAL TESTS ARE PERFORMED IN THE FACILITY AND ARE SUBJECT TO REVIEW BY THE CONTRACTOR. THIS DOCUMENT MEETS ALL SPECIFICATIONS LISTED.**

## Geography

**STATEMENT OF APPROVAL OF MANAGEMENT**

THE VARIOUS TYPES OF VENEERS

**INTERSTATE AND AMERICAN EXPRESS**

NOTICE OF SHIPMENT/  
PACKING LIST

Allegheny Technologies

SOLD TO →	FORMS DISTRIBUTION	SHIP TO →	SALES →

08/18/06 110977 | CUST. CODE | NEW CASTLE, IN. 524046 | ACCEPTING MILL | SHIPPER NO. | PRODUCT CODE | MILL ORDER NUMBER | DATE SHIPPED  
REPEAT ORDER | DO PHR RATE ORITY | GOVT CONTRACT | 13020102060000 | 30-096-051 | 12/12/06  
82037-4 26 | PRIME SEC. DSO DSO | MATL | SHIPPING LOCATION | INVOICE  
584 | 11.24 NEW CASTLE | IN | 072704

## CERTIFICATE OF TEST

GRADE AND SPECIFICATIONS  
CARRIER - BOHREN LOGISTICS, INC.  
ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E), (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

ITEM PCS DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG # / CD	SKID #
001 1 48./.062/2129.	824074	11066N273	7732493	21585	60	21525		150974	
IF POSSIBLE SHIP WITH LOAD 4111 TO DEL 12/12				21585	60	21525			
C CUST IDENTITY 00640									
1 SKID									

TYPE HEAT/TEST	--C---	--MN--	--P---	--S---	--SI--	--CR--	--NI--	--MO--	--CU--	--N---
HEAT 824074	.021	1.29	.034	.001	.35	18.28	8.03	.40	.45	.05

ITEM TEST NO 001 7732493 YIELD TENSILE % ELONG CORROSION GRAIN  
PSI \* PSI IN 2" % R/A HARDNESS BEND A 262 PRE SIZE  
T 47400. 92500. 58. 83.HRB T PASS PASS 8.  
\* Y.S. BY 0.2% OFFSET METHOD 82.HRB

ITEM TEST NO	MELT SOURCE	P&W E-25
001 7732493	1.	TRAN BEND
		2.

METALLOGRAPHIC MAGNIFICATION: 100X ETCHEANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE: Please Note- This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

## WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se

The above is a true copy of date on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

C. M. Napoli -  
Manager, Technical Information

12/12/06 10:17:44

# DART

## Purchase Order

Date Aug 16, 2007	Page 1
Purchase Order Number PO00004371	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawsbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

FAXED  
*Cy 07/08/07*

### Vendor Address:

G-1  
180 Avenue Labrosse  
Pointe Claire, QC H9R 1A1  
Phone (514) 630-4877  
Fax (514) 630-4849

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawsbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arriv.
		VC-GFI001	Aug 16, 2007	N30	Purolator	Aug 31, 2007

Q'ty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
200.0000	D2438B <i>150</i> <i>7/9/07</i> <i>50</i>	Clamp Comments: CUT & FORMED AS PER DWG D2438 REV. C B33937	8/31/2007	No	3.250000	Each	650.0
100.0000	D2171F <i>✓</i> <i>7/9/07</i> <i>50</i>	Clamp Comments: AS PER DWG D2171 REV. D CUT & FORMED B33936	8/31/2007	No	5.750000	Each	575.0

CERTIFICATE OF CONFORMITY  
REQD UPON DELIVERY

### Comments:

#### Tax Summary:

GST	73.50
GSTM	0.00
GSTD	0.00

Less: included tax	0.00
Subtotal	
Total tax	1,225.00
	73.50

Entered By: *CL* CLAVOIE